Work Order ID 102293-Z

May-27-13 2:25:11 PM

Required Date: 5/31/13

102293

Page 1

Item ID:

D3197-041

Accept

N900040100

Setup Start

Stop

Revision ID: Item Name:

5/27/13

Bar Assembly

Start Qty: 6.00 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Start Date:

Approvals:

Process Plan:

MLJ

Date: 13-05-27 Tooling:

Date:

Run

QC:

Date:

SPC (Y/N):

Date:

Stop

Start

Sequence ID/ Work Center ID

Operation Description

Set Up/ **Run Hours** Tool ID

Plan Tool #

Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

Draw Nbr

Revision Nbr

D3197 100

Rev B

100

BAND SAW

Bandsaw Jeaspa Bandsaw

Memo

Cut blanks: 29.125" long

0.00

13-5-29

110

110

HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

0.00

HAAS CNC vertical machine #1

1-Face ends to lenght per dwg D31972-Machine D3197-1 as per Folio FA340

and Dwg D31973-Deburr

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

Memo

0.00

Quality Control

May-27-13 2:25:11 PM Item ID:

Required Date: 5/31/13

D3197-041

Bar Assembly

Item Name: Start Date:

Revision ID:

5/27/13

OC:

Start Qty: 6.00

Req'd Qty: 6.00

Accept

N900040100

Setup Start

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date: Date: Tooling:

SPC (Y/N):

Date:

Date:

Run

Stop

Sequence ID/ Work Center ID

Conventional Lathe

Operation Description

Set Up/ **Run Hours** Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

130 *130* Lathe Conv

CONVENTIONAL LATHE

Memo

Chamfer as per Dwg D3197

0.00

0.00 \$ 13-5-29

140

140

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

and 13/05/31

150 HandFinish Hand Finishing Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

4 2613:63

150

102293

Page 3

May-27-13 2:25:11 PM

Item ID:

D3197-041

Accept

N900040100

Setup Start

Revision ID:

Item Name: Start Date:

Bar Assembly

5/27/13

Start Oty: 6.00 Req'd Qty: 6.00

Operation

Description

Cust Item ID:

Customer:

Reference:

Approvals:

Required Date: 5/31/13

Process Plan:

Date:

Tooling:

Date:

Start

OC:

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Stop

Sequence ID/ Work Center ID

160

170

QC

160 Powdercoat

Powder Coating

W1212101

Memo

START TIME:

Grey Sandtex(Ref:4.3.5.6) per QS1005 4.3

0.00

0.00

OVEN TEMPERATURE:

QC3-Inspect Part Finish

Memo

0.00

0.00

0.00

0.00

Quality Control

170

180

180 Small Fab

Small Fab

Small Fab

Memo

Assemble D3197-041 as per Dwg D3197

Run

Tool ID

Tool#

Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

4 \$ B-6-3



FF 13-06-04

Item ID:

May-27-13 2:25:11 PM

Required Date: 5/31/13

D3197-041

Accept

N900040100

Setup Start

Revision ID: Item Name:

Start Date:

Bar Assembly

5/27/13

Start Qty: 6.00 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Process Plan: Approvals:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

Operation Description QC5- Inspect part completeness to step on W/O

Set Up/ **Run Hours**

Tool ID Tool#

Accept Qty

Plan

Code

Reject Qty

Reject Number

Insp. Stamp

190 QC

190

Quality Control

Memo

200

200

Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

210

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

MLJ 13-06-05

Picklist Print

May-27-13 2:25:10 PM

Work Order ID:

102293

Parent Item:

D3197-041

Parent Item Name:

Bar Assembly

Comments:

IPP Rev: A New Issue 05-11-08 JLM

IPP Rev:B As per Rev B 06-03-10 JLM

Start Date: 5	/27/13
---------------	--------

Required Date: 5/31/13

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS27039-1-24 Screw		Purchased	No			100	Each	50.0000	2	12	F	F 13	-06-03
				Location		Loc Oty	L	oc Code					
				GA		50							
AN960JD10	NACI 1400002621			121	912	50				8			
Washer	NAS1149D0363J	Purchased	No	1243	392	180	Each	0.0000	6	36	-> H 3	EF 1	3-06-0
D2690-5		Manufactured	No	9		180	Each	9.0000	2		24	0	
Lanyard Assembly		manaractured				100	Lucii	9.0000	1 4 .	12	F	F 13	3-060
				Location		Loc Qty	L	oc Code		_			
				ST014		9		B10219	75	3			
				100	722	8				9 4			
D3242-1		Manufactured	No	919		180	Each	12.0000	2	#/			
Tag		Manufactured				100	Lacii	12.0000	2	12	FF	13-0	6.03
				Location		Loc Qty	Le	oc Code				- Property	
				GA		12	-						
D2400 2 200				100	723	12				9			
D3489-3-200 PIP PIN		Manufactured	No			180	Each	17.0000	2	12	F	13-	06.03
				Location		Loc Oty	Lo	oc Code					
				GA		17				Man			
				100	-	12				B 3			111111111111
				9610	-	5			-	5			

age 1

May-27-13 2:25:11 PM

Work Order ID:

102293

Parent Item:

D3197-041

Parent Item Name:

Bar Assembly

M7075T73R1.000

7075-T73 Rd Bar 1.00

Purchased

No.

Start Date: 5/27/13

Required Date: 5/31/13

Start Qty: 6.00

Required Qty: 6.00

2.42 18.15

Location Loc Qty Loc Code MAT012 65.32 120503 11.05 122386 6.27 125586 48 180 Each

180

17.625 Lt 12 FF 13-06-03

MS21042L3 Nut

Purchased

3,231.0000

65.3200

Location	Loc Qty	Loc Code	
FP001	3		
122141	3		
GA	18		
122452	18		
ST314	268		
117885	32		
119017	55		
119075	138		
123265	43		
ST506	2942		
123900	954		
124291	1988		g ne

DART AEROSPACE LTD	Work Order:	102293
Description: Bar	Part Number:	D3197-1
Inspection Dwg: D3197 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
29.00	+/-0.030	29.000			Tape	2T -10
25.06	+/-0.030	25.060			"	a l
11.44	+/-0.030	11 437			15	
0.500	+/-0.010	.505			vem	ZT-4
0.250	+/-0.030	.266			(1	d-i
Ø0.219	+0.005/-0.000	.220			4	
Ø0.191	+0.005/-0.000	.193				
1.000	+/-0.005	1,000			•	
2.69	+/-0.030	2.690				
1.000	+/-0.010	9861.00)		u.	
0.300	+/-0.010	,300				
0.063 x 45°	+/-0.010	.069			4	
Ø1.000	+/-0.010	.996			10	
				(2)		

Measured by:	ZT .	Audited by:	5ml	Prototype Approval:	N/A
Date:	13 05 30	Date:	13/05/31	Date:	N/A

Rev	Date	Change	Revised by Approved
Α	04.04.20	New Issue (P/O D3197-041)	KJ/JLM
В	07.03.09	Dwg revision update	KJ/JLM A

pgk. 206

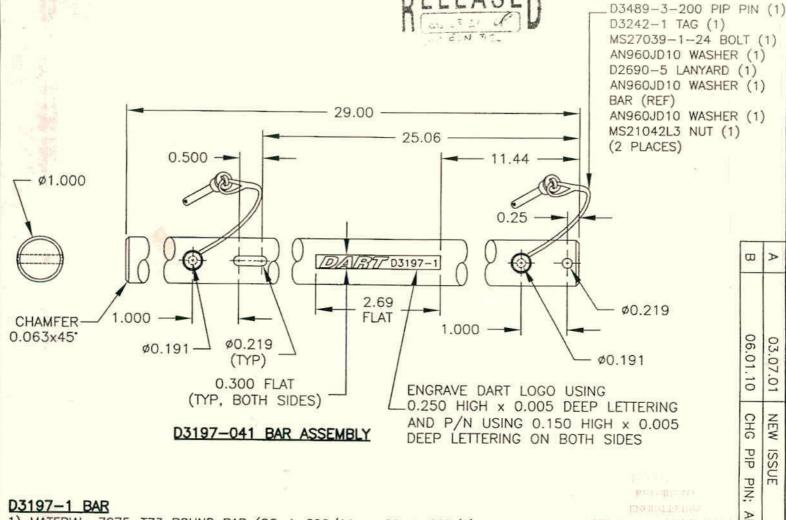
CP

AEROSPACE I

DRAWING NO.

SHEET

REV. 9



1) MATERIAL: 7075-T73 ROUND BAR (QQ-A-200/11 or QQ-A-225/9) Ø1.000 O.D. (REF DART SPEC. M7075T73R1.000)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT SANDTEX (4.3.5.6) PER DART QSI 005 4.3

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHEWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES

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DART A

AEROSPACE

FOR

ANY

PURPOSE

S

COPIED

5) FOR TOOLING, IT IS ACCEPTABLE TO HAVE A 0.06 DEEP x 60' CENTER MARK AT EITHER END OF THE BAR

03.07.01 CHG NEW PP ISSUE

90 DATE

.01.10

D